

Date: Monday, 22/10/2007 2:17:22 PM  
 J: Linda Lacelle

# Process Sheet

Split 307 12.12

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ARM
Job Number : 35298-3	
Estimate Number : 12884	Part Number : D3560044
P.O. Number :	Drawing Number : D3560 UNDER REVIEW
This Issue : 22/10/2007 S.O. No. :	Project Number : N/A
Prsht Rev. : NC	Drawing Revision : C
First Issue : 11	Material :
Previous Run : 35032	Due Date : 29/10/2007
Written By : <u>W</u>	Qty: 14 Um: Each
Checked & Approved By : <u>W</u>	
Comment : Est Rev:A New Issue 07.05.24 EC	
Est Rev B ECN 987 07.10.09 EC verified by DD	

## Additional Product

Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B0500X05000	6061-T6 Bar .50" x 5.0"
Comment: Qty.: 1.3598 f(s)/Unit Total: 19.0365 f(s) 6061-T6 Bar 0.50" x 5.00" Batch: <u>71106132</u>		
2.0	BAND SAW	BAND SAW
Comment: BAND SAW Cut blanks 15.500" long		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment: HAAS CNC VERTICAL MACHINING #1 1- Mill as per Folio FA696 Rev: <u>W</u> & Dwg D3560 Rev: <u>C</u> 2-C'sink 0.196" hole on manual mill as per dwg D3560 3-Deburr per dwg D3560		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
5.0	QC8	SECOND CHECK
Comment: SECOND CHECK		





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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 35298

Part Number: D3560044

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D35921

PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 14.0000 Each(s)  
PLATE

B41083

SP 08-09-02 (7K)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3560

STEP:

- 1- clean material (buff bracket and bottom of arm with blue pad ) SP
- 2- set up bracket and arm on jig SP
- 3- preheat bracket and arm with torch SP
- 4- clean before welding with brush SP
- 5- set up machine to 135 amps SP
- 6- weld across bottom and top ends SP
- 7- reheat with torch ( ) SP
- 8- on one side weld from bottom to top half way SP
- 9- same for other side (half way) SP
- 10- from half way point weld the rest of the first side (ease off pedal near end) SP
- 11- same for remaining side (ease off pedal near end) SP



8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SP 08-09-05 (7K)

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

SP 08-09-05 (7K)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

08-09-05







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## Process Sheet

Customer: CU DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 35298

Part Number: D3560044

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*Mf* 08/09/08 (2X)

12.0

D2808

Spacer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 14.0000 Each(s)

Spacer

batch:

*B37113*

*E* 08/09/08 (2)

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Press bushing in D3560 arm per dwg D3562

*E* 08/09/08 (2)

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*S* 08/09/08 (2)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

*pat. E.*

*S* 08/09/08 (2)

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/09

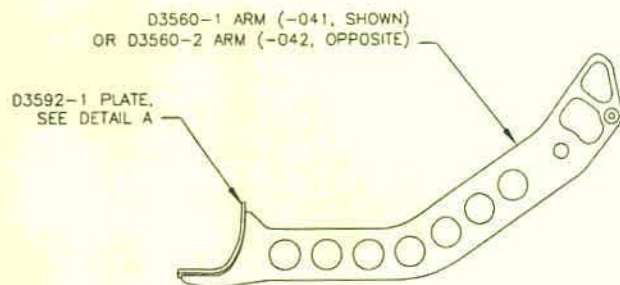
Job Completion



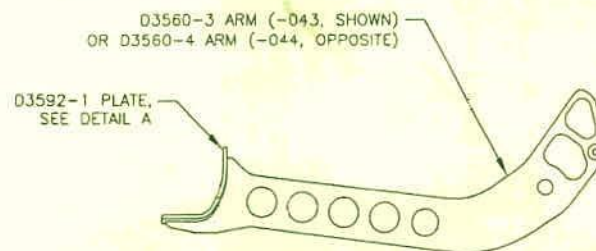
*mf* 08-09-09



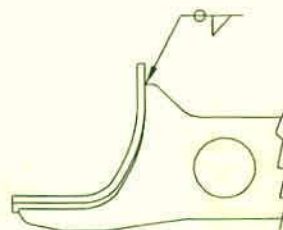
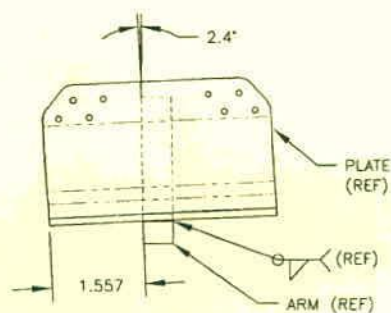




D3560-041 ARM WELDMENT (SHOWN),  
D3560-042 ARM WELDMENT (OPPOSITE)



D3560-043 ARM WELDMENT (SHOWN),  
D3560-044 ARM WELDMENT (OPPOSITE)



**DETAIL A**  
(SCALE 1:1)

**GENERAL NOTES**

- 1) WELD PER QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

**RELEASED**  
07.06.21  
**UNDER REVIEW**  
07.10.22 DC

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C	07.06.19	REMOVE POWDER COAT
B	07.01.15	REDESIGN AS WELDMENT, ADD POCKETS
A	06.09.25	NEW ISSUE
DESIGN	DRAWN BY	<b>DART</b> DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3560
DATE	07.06.19	TITLE ARM WELDMENT
		REV. C SHEET 1 OF 3 SCALE 1:4







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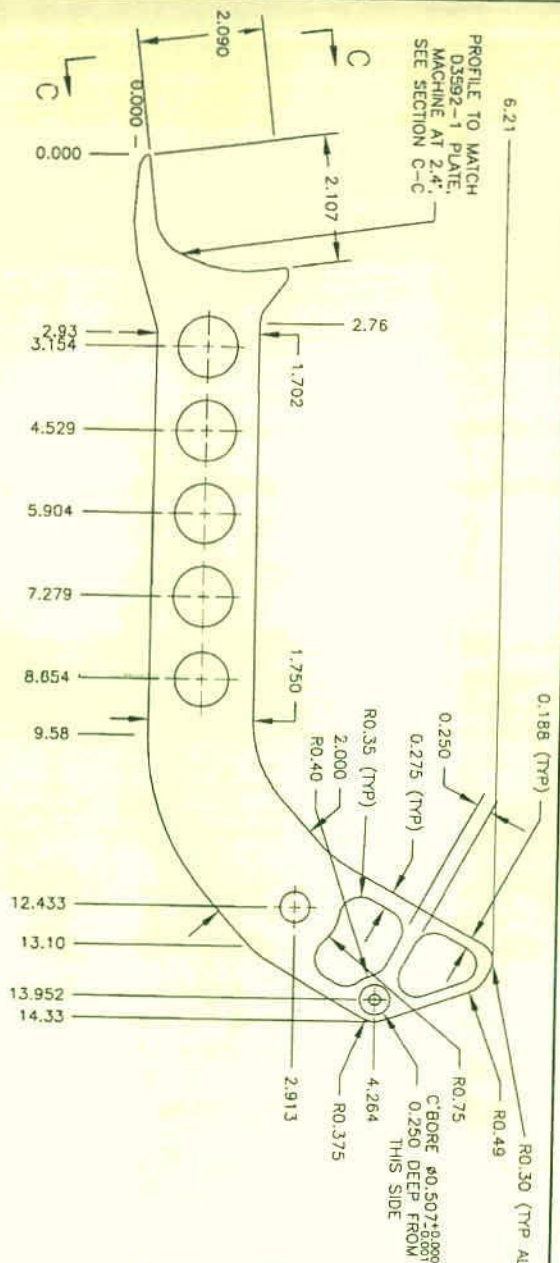
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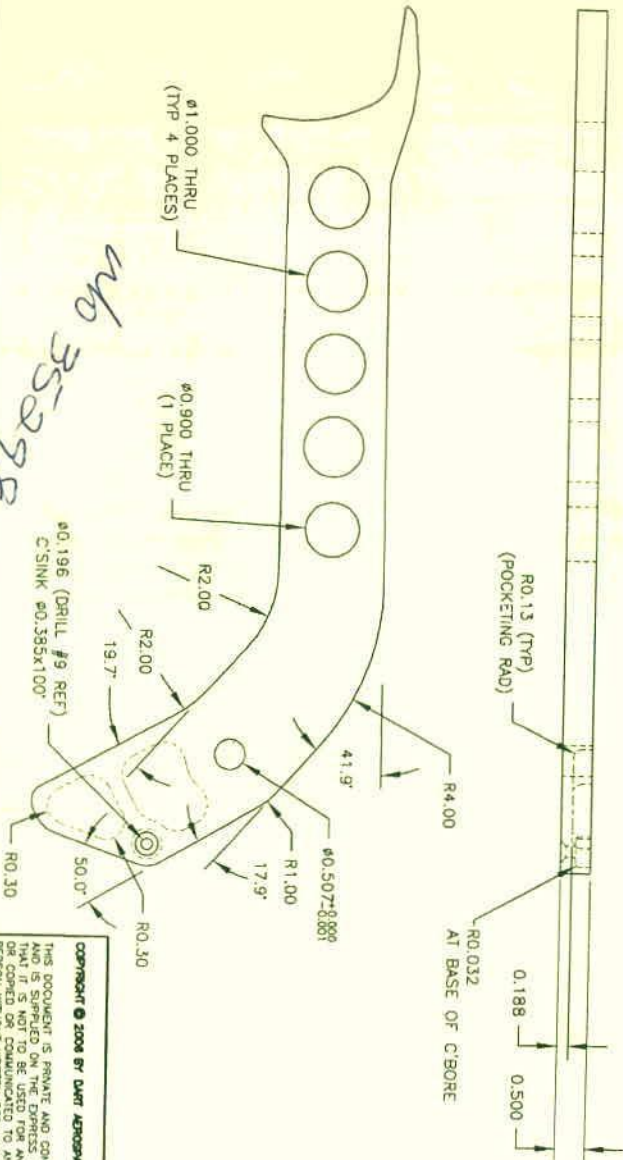
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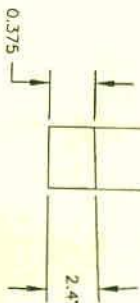




- D3560-3 ARM (SHOWN), D3560-4 ARM (OPPOSITE)**
- 1) MATERIAL: 6061-T6 ALUMINUM, 0.500 THICK  
(00-A-200/8 OR 00-A-250/11, REF DART SPEC.  
M6061T6B0.500)
  - 2) FINISH: NONE
  - 3) TOLERANCES ARE PER DART OSI 018 UNLESS OTHERWISE NOTED
  - 4) ALL DIMENSIONS ARE IN INCHES
  - 5) BREAK ALL SHARP CORNERS 0.005 TO 0.015



SECTION C-C  
VIEW ROTATED  
SCALE 1:1



46 35298

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DESIGN	Q4	DESIGN BY	Q4	DART	DART AEROSPACE LTD.
CHECKED		APPROVED		DRAWING NO.	D3560
DATE	07.06.19			TITLE	ARM WELDMENT
				REV. C	SHEET 3 OF 3
				SCALE	1:2

RELEASED  
07.06.19



1. The first part of the paper is devoted to the study of the properties of the function  $f(x)$  defined by the equation  $f(x) = \sum_{n=0}^{\infty} a_n x^n$ , where  $a_n = \frac{1}{n!}$ . It is shown that  $f(x)$  is an entire function and that  $f(x) = e^x$ .

2. In the second part, the function  $f(x)$  is studied in the case where  $a_n = \frac{1}{n!}$  and  $x$  is a complex number. It is shown that  $f(x)$  is an entire function and that  $f(x) = e^x$ .

3. The third part of the paper is devoted to the study of the properties of the function  $f(x)$  defined by the equation  $f(x) = \sum_{n=0}^{\infty} a_n x^n$ , where  $a_n = \frac{1}{n!}$ . It is shown that  $f(x)$  is an entire function and that  $f(x) = e^x$ .

4. In the fourth part, the function  $f(x)$  is studied in the case where  $a_n = \frac{1}{n!}$  and  $x$  is a complex number. It is shown that  $f(x)$  is an entire function and that  $f(x) = e^x$ .

5. The fifth part of the paper is devoted to the study of the properties of the function  $f(x)$  defined by the equation  $f(x) = \sum_{n=0}^{\infty} a_n x^n$ , where  $a_n = \frac{1}{n!}$ . It is shown that  $f(x)$  is an entire function and that  $f(x) = e^x$ .

6. In the sixth part, the function  $f(x)$  is studied in the case where  $a_n = \frac{1}{n!}$  and  $x$  is a complex number. It is shown that  $f(x)$  is an entire function and that  $f(x) = e^x$ .

7. The seventh part of the paper is devoted to the study of the properties of the function  $f(x)$  defined by the equation  $f(x) = \sum_{n=0}^{\infty} a_n x^n$ , where  $a_n = \frac{1}{n!}$ . It is shown that  $f(x)$  is an entire function and that  $f(x) = e^x$ .

8. In the eighth part, the function  $f(x)$  is studied in the case where  $a_n = \frac{1}{n!}$  and  $x$  is a complex number. It is shown that  $f(x)$  is an entire function and that  $f(x) = e^x$ .

9. The ninth part of the paper is devoted to the study of the properties of the function  $f(x)$  defined by the equation  $f(x) = \sum_{n=0}^{\infty} a_n x^n$ , where  $a_n = \frac{1}{n!}$ . It is shown that  $f(x)$  is an entire function and that  $f(x) = e^x$ .

10. In the tenth part, the function  $f(x)$  is studied in the case where  $a_n = \frac{1}{n!}$  and  $x$  is a complex number. It is shown that  $f(x)$  is an entire function and that  $f(x) = e^x$ .



